



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-541-051
Job Sheet 187442



Part No: D205-541-051

Job Qty: 1 ea

Part Name: Bell Medium Basket Automatic Lid Opener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9710 REV.C IPP REV:A 15.03.26 NEW ISSUE DD VERF:JLM IPP REV:B 16.05.24 as per dsi rev.b DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Stores/Pkg-1			DEC 10 2018
110	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging1-2			DEC 10 2018
120	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC4			DEC 10 2018
125	DC	1 pcs	12/14/18	12/14/18	0.00	0.00	DC			DEC 10 2018
130	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1			DEC 20 2018
140	QC21-FG	1 Ea	12/14/18	12/14/18	0.00	0.00	QC21			DEC 20 2018

Part Op 125 - Photocopy bluefile and create labels as per PPP D205-541-051 Chg 001
Descriptions: 130 - Identify and pack for shipping as per PPP D205-541-051

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5118190
AN3-20A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM138084-70X1 5078 252x2
AN310-4	Nut	4 Ea (4 ea)	90-Start up Operation	5082900
D3953-17	Gas Spring Spacer	6 Ea (6 ea)	90-Start up Operation	5117415
D3953-19	Gas Spring Bracket	2 Ea (2 ea)	90-Start up Operation	5120145
D3953-21	Gas Spring Bracket	2 Ea (2 ea)	90-Start up Operation	5112717
D3953-3	Gas Spring Stud, Lid	4 Ea (4 ea)	90-Start up Operation	5138740
D3953-7	Spring Spacer	4 Ea (4 ea)	90-Start up Operation	5115826
D3953-9	Gas Spring Washer	4 Ea (4 ea)	90-Start up Operation	5115399
D3969-9	Spring (Basket Lid)	2 Ea (2 ea)	90-Start up Operation	5146989
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	5094592
MS24665-231	Cotter Pin	4 pcs (4 ea)	90-Start up Operation	5113815
NAS1149F0332P	Washer	16 Ea (16 ea)	90-Start up Operation	5133206
NAS1149F0463P	Washer	4 Ea (4 ea)	90-Start up Operation	5097088

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-14A	4	294	0
	AN3-20A	4	27	0
	AN310-4	4	189	0
	D3953-17	6	27	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date: _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____
< Order Deviation		Disposition		
 Container No: S137346 Part: D205-541-051 Job No: 187442 Serial No/Batch: S137346 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH96 - 120 Issue 2, FAR 25.1309, FAR 25.1309		Completed By _____		
		Lead hand / Supervisor _____		
		QC / QA Coordinator _____		
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY		
☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function		
Other/Details: _____		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up		
☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread				

D3953-19	2	22	0
D3953-21	2	42	0
D3953-3	4	16	0
D3953-7	4	88	0
D3953-9	4	22	0
D3969-9	2	23	0
MS21042L3	8	3,364	0
MS24665-231	4	116	0
NAS1149F0332P	16	2,528	0
NAS1149F0463P	4	720	0

Part Specifications

Specifications could not be found.

Plex 12/4/18 12:59 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF. TCCA STC SH96-120,
FAA STC SR00696NY
EASA STC EASA.IM.R.S.01242

1.0 PURPOSE:

The purpose of this DSI is to provide operators of Bell 205/210/212/214/412 Rotorcraft equipped with Dart D205-541-043/-044/-045/-046 Heli-Utility-Baskets with an Upgrade Kit to replace the existing Lid Prop Arm Assembly with an Automatic Lid Opening Gas Spring Kit. The D205-541-051 Automatic Lid Opener Kit includes parts and hardware to install a gas spring on both ends of the D205-541-043/-044/-045/-046 basket.

2.0 PARTS LIST:

ITEM No.	QTY -051	PART NUMBER	DESCRIPTION
	X	D205-541-051	AUTOMATIC LID OPENER KIT
1	4	D3953-3	GAS SPRING STUD
2	4	D3953-7	GAS SPRING SPACER
3	4	D3953-9	GAS SPRING WASHER
4	6	D3953-17	GAS SPRING SPACER
5	2	D3953-19	GAS SPRING BRACKET
6	2	D3953-21	GAS SPRING BRACKET
7	2	D3969-9	GAS SPRING
8	4	AN3-14A	BOLT
9	4	AN3-20A	BOLT
10	4	AN310-4	CASTELLATED NUT
11	8	MS21042L3	NUT
12	4	MS24665-231	COTTER PIN
13	16	NAS1149F0332P	WASHER
14	4	NAS1149F0463P	WASHER

NOTE:

For customers wishing to order new baskets with the Lid Opener pre-installed, use the following numbers:

D205-541-043 BASKET with AUTOMATIC LID OPENER installed = D205-541-043A
D205-541-044 BASKET with AUTOMATIC LID OPENER installed = D205-541-044A
D205-541-045 BASKET with AUTOMATIC LID OPENER installed = D205-541-045A
D205-541-046 BASKET with AUTOMATIC LID OPENER installed = D205-541-046A

3.0 PROCEDURE:

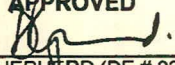
For D205-541-043/-044/-045/-046 Heli-Utility Baskets, replace the existing Prop Arm Assembly with gas springs on both ends of the basket. (NOTE: Once this modification is complete, it will not be possible to re-install the D2332-041 Prop Arm Assembly)

3.1 Remove the D2332-041 Prop Arm Assembly.

3.2 Grind flush and deburr the D2327-3 Spacer Bushing from the end of the basket base. Touch up paint per ICA-D205-541, Section 5.1.5.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 17.01.11
CERT. NO.: SH96-120
ISSUE NO.: 3

C	REMOVED -053, UPDATE APPLICABILITY OF -051 KIT REASON PAR17-572	SAD	17.01.11
B	FLIP GAS SPRING ORIENTATION, ADD D3969-9 ADD-053 KIT, NAS1149F0332P WASHER WAS 0363P	CP	16.05.12
A	NEW ISSUE	DB	15.02.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9710	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AUTOMATIC LID OPENER INSTL	NTS
DATE	17.01.11	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Change Record

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Part Number: D205-541-051Description: AUTOMATIC LID OPENER[illegible]

